

Work Order ID 73861 *LT*



Page 1

Friday, September 16, 2011 1:30:42 PM

Item ID: D206-642-151

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 9/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *MF*

Date: *11-09-19*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3804	A								
IIN-D206-642	O								

100

0.00



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804								
	3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty <input type="checkbox"/> Part Number <input type="checkbox"/> Description <input type="checkbox"/> Batch A/R <input type="checkbox"/> Aluminum Rod <input type="checkbox"/> <i>M117884</i>								
	4-Grind weld flush to cap on top surface only.								
	5-Cut Aft end as per dwg D3804 from front of tube and Deburr								
	6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804								
	7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.								
	8-Drill pilot holes using Dt8166 & DT8169D & DT9771.								
	9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.								
	10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.								

MO/

11-9-22

BE 11/10/04

SAD 11-10-21 (1)

SAD 11-10-25 (1)

SAD 11-10-26 (1)

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

5/11/10/27

④

SAD 11-10-26

OC 11/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Accept

**Setup Start**

Stop



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Cust Item ID:[illegible]

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Date: _____ **SPC (Y/N):** _____ **Date:** _____

[illegible]

HandFinish

Memo

0.00

Hand Finishing

0.00



QC

Memo

0.00

Quality Control

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open holes to finished size as per Dwg D3804, (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

22 11/10/21



11-10-27

11-10-27

W/O:		WORK ORDER CHANGES					
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		CS-C						

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 	QC6- Inspect dimensions to drawing	0.00							
QC Quality Control	Memo	0.00				1	0	BE 11/10/27	
180 	Skidtubes	0.00							
Skidtubes Skidtubes	Memo	0.00							
	1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required								dc 11/10/27
	2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting								
	Start Date: <input type="checkbox"/> 11/10/27 <input type="checkbox"/> Time: <input type="checkbox"/> 5:00 <input type="checkbox"/>								
	Finish Date: <input type="checkbox"/> 11/10/28 <input type="checkbox"/> Time: <input type="checkbox"/> 10:00								
	Pick:								
	Qty <input type="checkbox"/> Part Number <input type="checkbox"/> Description <input type="checkbox"/> Batch								
	A/R <input type="checkbox"/> Sikaflex-291 <input type="checkbox"/> 119377 <input type="checkbox"/>								
	Sikaflex expire date: <input type="checkbox"/> 12/08/13								

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 0 BE a/p/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty ☐ Part Number ☐ Description ☐ BatchA/R ☐ Aluminum Rod ☐ M117884

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R ☐ SS Rod ☐ NONE BE 11/10/31

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 11/10/28

B 11/10/31

DP 11-11-1

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 HandFinish Hand Finishing	HandFinishing Memo Install D2680-041 Nut Plate as per Dwg D3804	0.00 0.00							
220 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				1	0		
230 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1	0		

DP 11-11-1

11.11.01

11.11.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 9/16/2011 Start Qty: 1.00



Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

*Handwritten: 11/11/01 ①
1X m-f 11/11/02*

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

*Handwritten: 2:30
320 OF
3:00*

Handwritten: 1X m-f 11/11/02

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten: 1 htl of 11/11/07

Handwritten: M118434

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

16H 6 Jul 11 107

280

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive
A/R ☐ Sikaflex-291 ☐ 11/19/11
Sikaflex expire date: ☐ 12/01/11

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and QSI 005 4.4

Batch: 11118988

16H 6 Jul 11 115

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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290 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

11 - 11 - 15 (1)

300 QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

11 - 11 - 15 (1)

310 Packaging 0.00



Packaging Memo 0.00

Packaging Identify and pack for shipping as per PPP D206-642-151

Location: _____
PPP Rev: _____

PPP 74337

11/16/16

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

320

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/17
MF
11-11-16

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No			110	Each	12.0000	1	1			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--



Skidtube, 206 Skidtube

Location	Loc Qty	Loc Code
LG	73786	12
68136	1	
71616	5	
71617	6	

max 11-9-22

D2647		Manufactured	No			110	Each	44.0000	1	1			
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Cap

Location	Loc Qty	Loc Code
LG002	44	
55352	14	
71171	30	

BE 11/10/04

CR3212-4-04		Purchased	No			180	Each	1,655.000	52	52			
-------------	--	-----------	----	--	--	-----	------	-----------	----	----	--	--	--



Cherry Rivet

Location	Loc Qty	Loc Code
ST311	119017	1655
116471	78	
117816	477	
118686	100	
118840	1000	

52

11/10/27

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2654-1
Web

Manufactured No

180 Each

6.0000

1

1

Location

Loc Qty

Loc Code

LG

6

64562

6

D3286-1
Doubler

Manufactured No

180 Each

32.0000

2

2

Location

Loc Qty

Loc Code

LG002

32

52844

11

64563

21

D2649
Cross Bolt Spacer

Manufactured No

200 Each

289.0000

19

19

Location

Loc Qty

Loc Code

LG

6

68224

2

71355

2

72704

2

LG001

283

65317

1

68507

11

73390

271

D3286-3
Spacer

Manufactured No

200 Each

27.0000

2

2

Location

Loc Qty

Loc Code

LG002

27

64564

27

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Page 3

Friday, September 16, 2011 1:30:39 PM

Work Order ID: 73861

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

210

Each

19.0000

1

1



Nut Plate

Location

Loc Qty

Loc Code

ST020

23854

19

55366

17

70088

2

① 11-11-1

CR3212-4-03 Purchased No

210

Each

1,138.000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

114859

1136

1136

② 11-11-1

AN960JD416 NAS1149D0463J Purchased No

210

Each

0.0000

1

1



Washer

CCR264SS3-3

Purchased No

210

Each

435.0000

2

2



Cherry Rivet

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

117086

433

117849

23

410

② 11-11-1

Friday, September 16, 2011 1:30:39 PM

Shop Packet Print

Page 3

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Friday, September 16, 2011 1:30:39 PM

Work Order ID: 73861

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

29.0000

1

1



Screw



ul 9/16/07

Location

Loc Qty

Loc Code

FP-A

8

1119124

x1

115460

8

ST292

21

115460

21

D2651-1

Manufactured

No

270

Each

289.0000

6

6



Plug



ul 9/16/07

Location

Loc Qty

Loc Code

fpa

109

1373827

x6

69018

109

FP-A

180

57869

1

66445

10

67760

36

70691

100

70839

2

71037

31

D2651-3

Manufactured

No

270

Each

799.0000

6

6



O-Ring



ul 9/16/07

Location

Loc Qty

Loc Code

FP-A

799

61962

12

66956

282

73489

505

x6

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Work Order ID: 73861

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

280

Each

160.0000

14

14



Bushing



Handwritten: 14

Handwritten: 14

Location

Loc Qty

Loc Code

ST084

4

B73830

Handwritten: X14

68247

4

ST088

156

64760

1

70690

54

71837

101

D2646 Manufactured No

280

Each

89.0000

1

1



Aft Cap



Handwritten: 1

Handwritten: 1

Location

Loc Qty

Loc Code

FP004

45

68280

45

FP006

5

62678

5

FP-4

35

70945

1

71070

34

fp5

4

71038

4

B73294

Handwritten: X1

D3805-041 Manufactured No

280

Each

0.0000

1

1



Wearplate Assembly Fwd, Low Gear



Handwritten: 1

Handwritten: B75947 (X1) 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Friday, September 16, 2011 1:30:40 PM

Work Order ID: 73861

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,296.000

2

2



Screw



Handwritten: 2 9/16/11

Location

Loc Qty

Loc Code

ST291

1296

115108

96

117423

300

118378

400

118910

500

Handwritten: x2

MS21042L3

Purchased

No

280

Each

1,603.000

7

7



Nut



Handwritten: 7 9/16/11

Location

Loc Qty

Loc Code

ST300

1603

117441

24

117601

374

117885

205

118451

1000

Handwritten: x7

D3805-045

Manufactured

No

280

Each

6.0000

1

1



Wearplate Assembly Aft, Low Gear



Handwritten: B 74938(x1) 9/16/11

Location

Loc Qty

Loc Code

FP

6

70878

6

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2



Washer



Handwritten: M117087 (x2) 9/16/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 7

Friday, September 16, 2011 1:30:40 PM

Work Order ID: 73861



Parent Item: D206-642-151



Parent Item Name: Replacement Skidtube

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-37A

Purchased

No

280

Each

261.0000

7

7



Jul 11/11/07

Bolt

Location

Loc Qty

Loc Code

ST353

211

111668

111

118628

100

ST354

50

117619

50

X7

NAS1149D0363J

Purchased

No

280

Each

2,623.000

7

7



Jul 11/11/07

Washer

Location

Loc Qty

Loc Code

ST298

2623

117601

308

118077

1315

118612

1000

X7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER
DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5
INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE
BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN
THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

* 73861

RELEASED
09.03.03

PC ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97		
DRAWN	97		
CHECKED	97		
MFG. APPR.	97		
APPROVED	97		
DE APPR.	97		
DATE	08.07.07		

DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWING NO. D3804	REV. A SHEET 1 OF 5
TITLE SKIDTUBE ASSEMBLY, 206A/B	SCALE NTS

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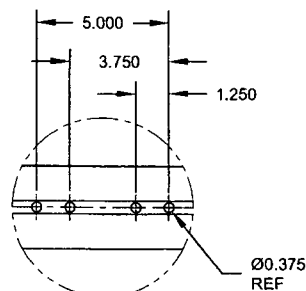
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

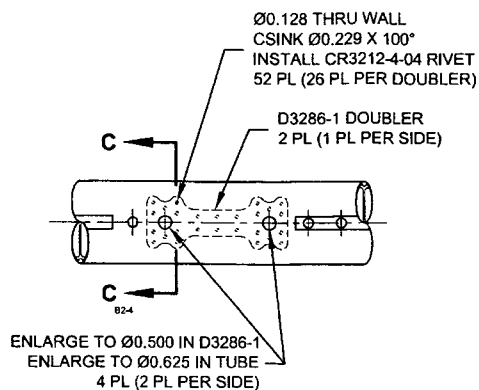
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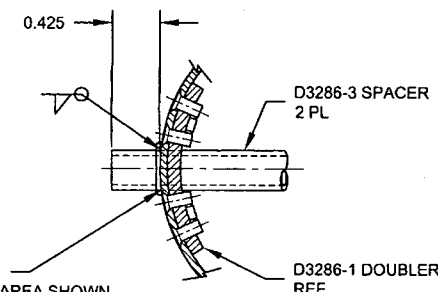
RELEASED
UP 09.03.07



DETAIL A
SCALE NONE
D5-2
C2-2
D5-3
C2-3

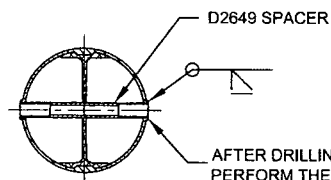


DETAIL B
SCALE NONE
C3-2
C3-3



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



SECTION D-D A4-2
FOR Ø0.375 HOLES ONLY
SCALE NONE
A4-3

- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

7386

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 4 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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RELEASED
99 09.03.03

CCR264SS3-3
RIVET
2 PL

CR3212-4-03 RIVET
2 PL

VIEW G-G
SCALE NONE
A7-5

D2647 CAP. TO INSTALL:
1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS REQD)
4. WELD D2647 IN PLACE
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

MS27039-4-06 SCREW
AN960JD416 WASHER

D2680-041
NUTPLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

1/16

DETAIL E
SCALE NONE
B7-2
B7-3

0.400

END OF WEB

SEAL WITH
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204
REF

MS27039-1-08 SCREW
AN960JD10L WASHER
2 PL

BORE OUT END
OF SKIDTUBE
TO 0.75 DEPTH
AND 0.070 WALL

DETAIL F
SCALE NONE
B2-2
B2-3

#73861

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO.	REV. A
MFG. APPR.	99	D3804	SHEET 5 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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